

Work Order ID 131130

131130

Page 1

March-26-15 1:44:02 PM

Item ID: D2611 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearing
 Start Date: 3/26/15 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: MCD Date: 15-03-31 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2611	Rev C								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 27963 Purchase part as per Dwg D2611 Possible supplier:
 McMasterP/N: 63215K34 Material release note required

CL 15/03/31 40

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure certificate of conformity is attached

40x 5015-042

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

(40) DAS 38 9-89
 APR 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

March-26-15 1:44:02 PM

Item ID: D2611

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bearing

Stop *NS2*

Start Date: 3/26/15 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 3/26/15 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

Accept	Qty
--------	-----

Reject
Qty

Reject Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location: ST 01/2A 0.00

130

Packaging

Memo

0.00

Packaging

40

APR 07 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 1504-05

115-47

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

March-26-15 1:44:02 PM

Page 1

Work Order ID: 131130

131130

Parent Item: D2611

D2611

Parent Item Name: Bearing

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:B99.06.23Re-formatDM
Change to SS; Change Supplier- Rev.C 07.03.14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
63215K34		Purchased	No				Each	0.0000		40			
63215K34									**				
Bearing													

40x SPIS-04-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Material									
Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

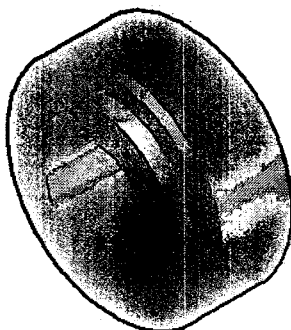
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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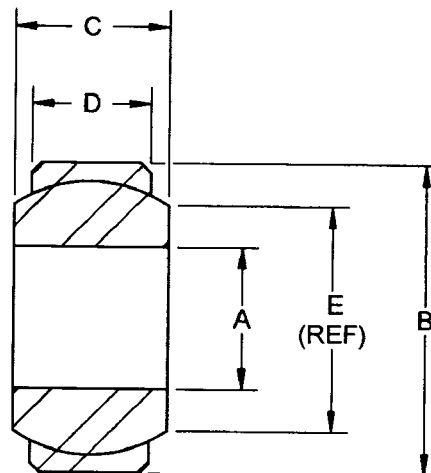
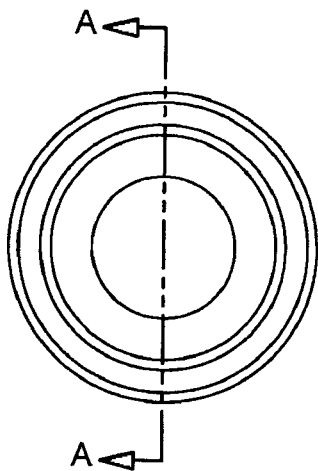
DESIGN 9P	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2611	REV. C SHEET 1 OF 1
DATE 06.09.20	TITLE BEARING		SCALE NTS
REV	DATE	DESCRIPTION	
A	97.07.31	NEW ISSUE	
B	01.07.04	RE-DRAWN	
C	06.09.20	CHANGE TO SS; CHANGE SUPPLIER	

SPECIFICATION CONTROL DRAWING



RELEASED

06.11.17 #



SECTION A-A

UNCO
 STAINLESS
 304
 1503-31
 131130 MCT

A	B	C	D	E (REF)	POSSIBLE SUPPLIER
0.375	0.813	0.406	0.313	0.592	McMASTER-CARR P/N 63215K34

NOTES:

- 1) STAINLESS STEEL BALL JOINT SWIVEL BEARING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART
SPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27963**

Purchase Order Date 3/31/2015

PO Print Date 3/31/2015

Page Number 3 of 4

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

6 63215K34

Bearing

4/1/2015

Yes

4/1/2015

40.00

Each

\$17.24

\$689.60

AS PER DWG D2611 REV. C
B131130

Spiral-2

Line Total:

\$689.60

7 71550-11

9198K16 303 ROUND
BAR 5" DIA

4/1/2015

Yes

4/1/2015

1.00

Each

\$154.08

\$154.08

1 PCS OF 3 FT

Line Total:

\$154.08

Deliver To: JEAN-LUC

8 71400-40

19525T13 HIGH
TEMPERATURE CASTER

4/1/2015

Yes

4/1/2015

4.00

Each

\$23.53

\$94.12

Line Total:

\$94.12

Deliver To: LUC

Note:

3/31/2015



Packing List

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Deliver To Luc

Purchase Order
PO27963
Order Placed By
Chantal Lavoie

McMaster-Carr Number
1428983-01

Page 1 of 1

03/31/2015

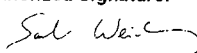
Line	Product	Ordered	Shipped
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer	1 Each	1 ✓
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10	5 Packs	5 ✓
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	8 Each	8 ✓
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25	2 Packs	2 ✓
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1 ✓
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick	40 Each	40 ✓
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long	1 Each	1 ✓
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity Your Part Number: 71400-40	4 Each	4 ✓
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc Your Part Number: 71400-40	4 Each	4 ✓

McMaster-Carr Supply Company 200 Aurora Industrial Pkwy Aurora, OH 44202-8087 USA Phone: 330-995-5500 Fax: 330-995-9600 E-Mail: cle.sales@mcmaster.com Employer Identification Number (EIN): 36-1458720		Invoice: 26682794 Purchase Order: PO27963 Release: McMaster-Carr Number: 1428983-01		ORIGINAL COMMERCIAL INVOICE CERTIFICATE OF ORIGIN	
Ultimate Destination: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Shipped: 31-Mar-2015		FOB: ORIGIN	
Intermediate Consignee:		Bill To: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Tax Number:	
Forwarding Agent:		Billing Attention: Shipping: Deliver To Luc Attention: Contact:			

Line	Description	Qty & Unit	Unit Price	Extension
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer Country of Origin: United States Schedule B #: 400821 ECCN #: EAR99 NLR	1 EA	\$102.55	\$102.55
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10 Country of Origin: Taiwan Schedule B #: 731816 ECCN #: EAR99 NLR	5 PK	\$3.83	\$19.15
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	8 EA	\$17.14	\$137.12
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25 Country of Origin: Taiwan Schedule B #: 731822 ECCN #: EAR99 NLR	2 PK	\$6.66	\$13.32

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.

Shipping Weight (in kgs): 21		Number of Packages: 1		Invoice Amounts:		Merchandise Amount: \$1,284.06 Total (in USD): \$1,284.06	
Package Dimensions: 64 X 33 X 34 CM = .071 CUBIC M				Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days			
Authorized Signature: 		Date: 31-Mar-2015		Remit payment to: (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA		(by wire transfer) Bank of America Illinois 231 S LaSalle Chicago, IL 60697 ABA 071000039 Account 86666-02021 SWIFT BOFAUS3N	
Name: Sarah Weinberg		Title: Operations Mgr.		Page 1 of 2			

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500
E-Mail: cle.sales@mcmaster.com

Fax: 330-995-9600

Employer Identification Number (EIN): 36-1458720

Invoice: 26682794

Purchase Order: PO27963

Release:

McMaster-Carr Number: 1428983-01

ORIGINAL COMMERCIAL

INVOICE

CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$8.60	\$8.60
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	40 EA	\$17.24	\$689.60
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long Country of Origin: Sweden Schedule B #: 722211 ECCN #: EAR99 NLR	1 EA	\$154.08	\$154.08
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$23.53	\$94.12
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$16.38	\$65.52
	NOTE Tracking number(s) for this shipment: 633862298275			

Number of Packages: 1

Page 2 of 2